

If possible, the jig should be drawn full size, as it is a great deal easier to obtain the correct proportions when so doing. Of course, in many cases, it will be impossible to draw the jigs full size. In such cases the only thing to do is to draw them to the largest possible regular scale. Every jig draftsman should be supplied with a set of blueprints containing dimensions of standard screws, bolts, nuts, thumb-screws\* washers, wing-nuts, sliding points, drills, eounterholes, reamers, bushings, etc.; in short, with blueprints giving dimensions of all parts that are used in the construction of jigs, and which are, or can be standardised. It should be required of every designer and draftsman that he use these standards to the largest possible extent, so as to 'bring the cost of jigs down to as low a figure as possible,

It is highly desirable, for the obtaining of best results, that, before starting on the drawing, the draftsman who is to lay out the jig should consult the foreman who is initially going to use the jig. Oftentimes this man will be \*ihlr t<\* Miph the best idea for the making of the jig ur tool. Hit\* lumhined experieme of the draftsman and the foreman will jtcfietalh produtr a much better tool than could either of them alone.

As a jig drawing, in most cases, is only u \*nl «wi e. «»r at most only a very few times, it is not advisable to nuKe a I rut ing or blueprint from the drawing, but, as a rule\* I lit\* pern II drawing itself may be used to advantage. If, however, if i\ given out in the shop directly as it comes from the dfMvuttft hoard, it B likely to become soiled, so that, after ;t wftIK it would In\* impossible to mate out the meaning of tin\* vim t »<h<mit un it, Fur thin reason jig drawings should be made tm hra\l pajwr, preferably of brown color, which is not as quit My sojrlil 4\* white paper; and in order to prevent the drawing lititsi hrwtf torn, it should be mounted on strawboard, and held duwu ,ilung thr rdgr.s by thin wooden strips, nailed to the board, ft |>> .&\*\* iii-4nible to

cover the drawings with a thin rmti of lliry  
are sent out into the shop. When thin k «It>iti,% rirl and Muck  
may be washed off tiimlly; ami the itM-lf may Iw wished  
off by wood alcohol, when the is return-d tu the draft-  
ing-room. The drawing, after then *h*